Work Orde Friday, September				*106	3570*			ship,	المكالو		Page 1
Revision ID:	D3870-042			Accept	*N900	<u> </u>	100	7* s	Setup Star	1/1	S1*
	Hardpoint, FV 9/6/2013	WD RH  Start Qty: 1.00	*1*		Cust Item	ID:			Sto	° *N.	S2*
Required Date: Reference:	9/12/2013	Req'd Qty: 1.00	*1*		Customer:						i
Approvals:	Process Pla	in: UMF.	Date: 39-6	Tooling:	D	ate:	· •	R	lun Stai	<i>"\</i>	R1*
	QC:	<del></del>	Date:	_ SPC (Y/N):	D	ate:	-		Sto	*N	R2*
Sequence ID/ Work Center ID	 )	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr	· · · · · · · · · · · · · · · · · · ·								
D3870	À										ĺ
*1 \\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		**** lt is a	le D3870-1 to D3870-3 and vacceptable to grind corners to ninum welding rod batch:	facilitate fitting to the D	3870-1****			_Ø	E	13 <u>-9</u> -9	
*110		QC9- Inspect visual pe	er QSI004- Fusion Welds	0.00				٠			DAG,
QC Quality Control		Memo		0.00				_U	, <u>"1</u> 2·¿	76 <u>-5</u> 5	
*120		QC5- Inspect part com	pleteness to step on W/O	0.00							(D40
QC Quality Control		Мето	1	0.00				D	)\Z-r	76'0 2	(

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Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Ď.	ng Gear  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				p/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque V	Vaves in I	Extrusion	ո 🗀	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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Work Orde Friday, Septemb				*106	570*				Page 2
Item ID: Revision ID: Item Name:	D3870-042 Hardpoint, FV	WD RH	7,2	Accept	*N900040	100	)* ·	Setup Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	9/6/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:				IND.
Approvals:		an:	Date:	Tooling: SPC (Y/N):	Date:	- <del>-</del> -	I	Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID	<u>-</u>	Operation Description	······································	Set Up/ Run Hours	Tool ID Tool #	Plan Code	Accept Qty		Reject Insp. Number Stamp
130		Chemical Conversion Co	oat per QSI005 4.1	0.00		Code	213	- •	•
*130* HandFinish Hand Finishing		Memo		0.00			_/	76	13940
<sup>140</sup> <b>*1∆∩</b> *		QC3- Inspect Part Finish	1	DAS 27 0.00 9-89	Ą		1		
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	$\square$	Torque W			٠ <u> </u>	Drawing		•	Calibration -			<u> </u>	·
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Work Orde Friday, Septemb				*106	3570*				<u></u>			Page 3	
Item ID: Revision ID: Item Name:	D3870-042	WD RH		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	1/1	S1* S2*	
Start Date: Required Date: Reference:	9/6/2013 9/12/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:					IV	: :	
Approvals:	Process Pla	an:	Date:	Tooling: _	Da	te:			Run	Start	*N	R1*	
	QC:	<del></del>	Date:	SPC (Y/N):	Da	te:				Stop	*N	R2*	
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp	
*160 *160* <sup>QC</sup>		QC21- Final Inspection	- Work Order Release	0.00				s.		13/	9/1	19	

Quality Control

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Outside Dimensions

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Wave/Twist in Tube

Folio

## **Picklist Print**

Friday, September 06, 2013 1:34:18 PM

Work Order ID:

106570

Parent Item:

D3870-042

Parent Item Name:

Hardpoint, FWD RH

Start Date: 9/6/2013

Required Date: 9/12/2013

Start Qty: 1.00

Required Qty: 1.00

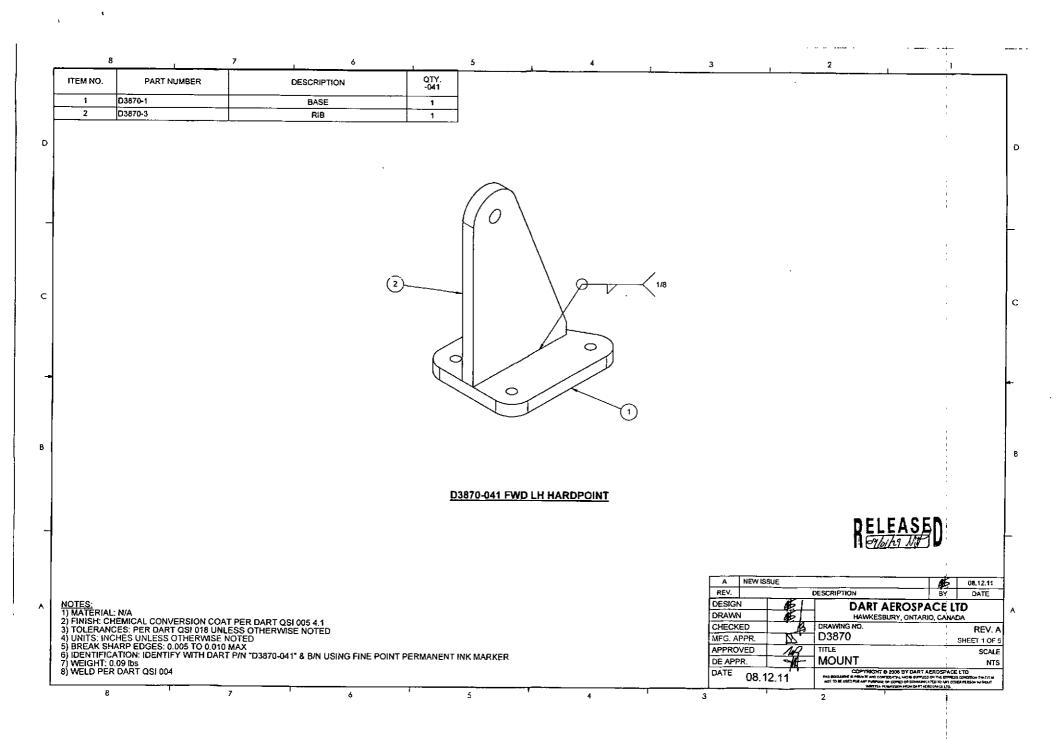
Comments:

IPP Rev:A 09-01-20 as per prelim issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3870-1 Base		Manufactured	No			100	Each	2.0000	1	EL_13	· 9- 9		
<b>D3870-3</b> Rib		Manufactured	No	Location WA002 449	58	Loc Qtv 2 2 100	<u>Lo</u> Each	c Code 2.0000	1	<u> </u>	<u> </u>	- <del>Marie</del>	
				WA004	59	<u>Loc Qty</u> 2 2	<u>Lo</u>	<u>c Code</u>				•	

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	$\vdash$	Cracks	or conce		""  —	Broken/Damaged	$\vdash$	ł	ion Incomplete	<u> </u>	Part Incorre	<b>⊢</b>	Weld
	$\vdash$		Crimped		-	Burrs	_	1	tions Incomplete/	Unclear	Part Lost/M	<b>⊢</b>	Wrong Stock Pulled
	Crushed/Crimped Cuffs					Contamination	$\vdash$	1	enance		Part Moved	_	
	Heat Treat					Countersink		Mislabe	eled		Positioned V	Vrong	
	Inspection Strip in Tube					Cut Too Short	$\vdash$	Misrea			Power Loss/		Other
	Ripples in Bend					Drill Holes		Offset					
Torque Waves in Extrusion					,	Drawing		Out of	Calibration				
Turning Sequence					<u> </u>	Finish		Out of :	Sequence				
	Wave/Twist in Tube					Folio		Outside	Dimensions				



											DQA.	Date	
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Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

2 3 QTY. -042 ITEM NO. PART NUMBER DESCRIPTION D3870-1 BASE 1 2 D3870-3 RIB ٥ C D3870-042 FWD RH HARDPOINT NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3870-042" & B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.09 lbs
8) WELD PER DART QSI 004 DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A D3870 MFG. APPR. SHEET 2 OF 5 APPROVED TITLE SCALE DE APPR, MOUNT NTS COPYRIGHT © 2006 BY CART A ERCOSPACE LTD

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						Rework	-		Skid-tube Crosstut	-	1	Water Jet	Engineering
Part N	۷o.					Scrap	4	1	Machining Small Fa	- ⊢	4	d. Eng. Coor.	Quality
						Use-as-is	_	Thern	noforming Finishir	-⊢	Rec/Stor	e/Packaging	Other
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Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved
Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

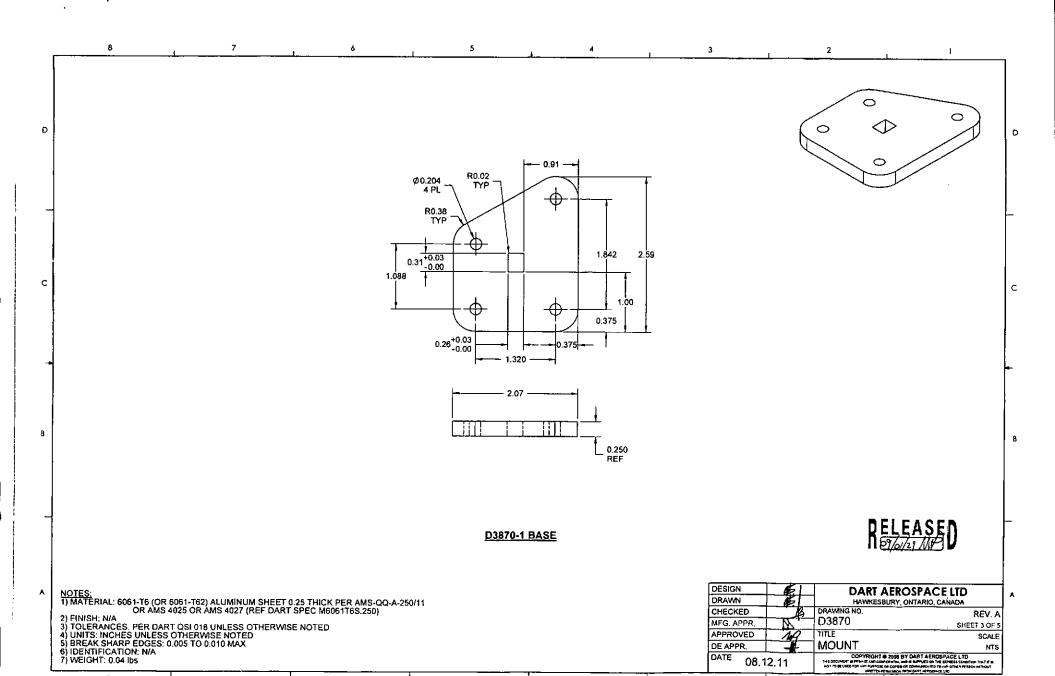
Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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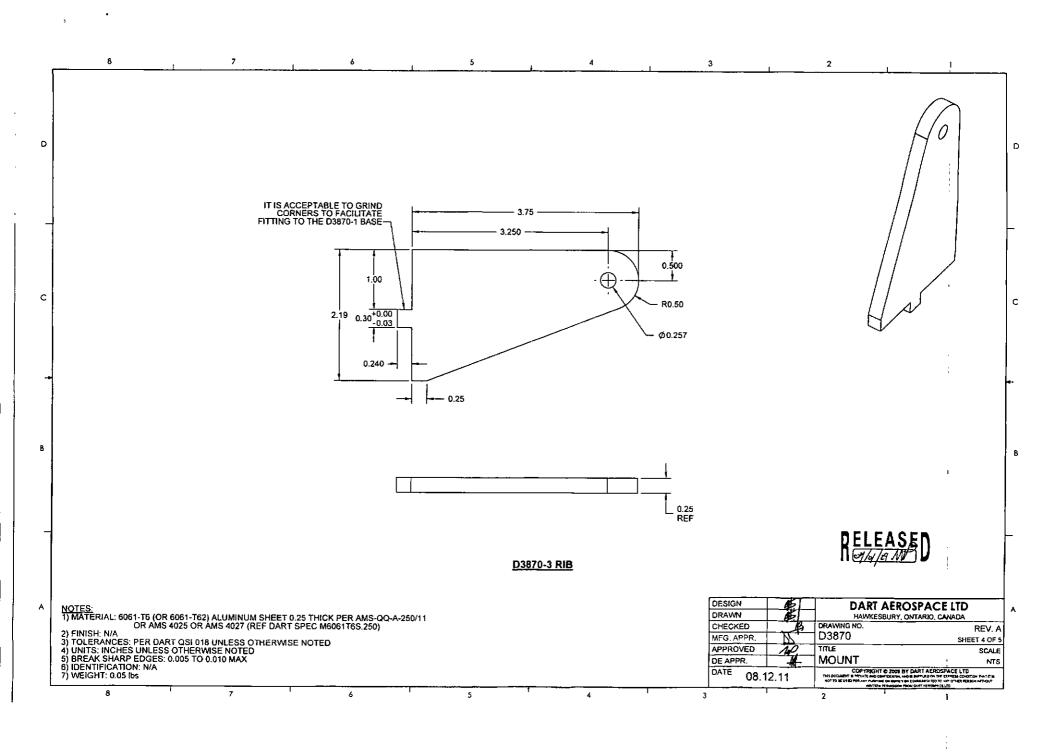
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		DQA:	Date: '	,
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NCR: Yes / No

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	··				Use-as-is	1 I	Therm	noforming	Finishing	Rec/Store/Packaging Oth				Other
NCR N	lo				Work Order Update	]		Large Fab	Composite		Supplier			
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Ī	Ripples in	Bend			Drill Holes		Offset		_					
Ţ	Torque W	Vaves in E	Extrusio	n 🗀	Drawing		Out of (	Calibration						
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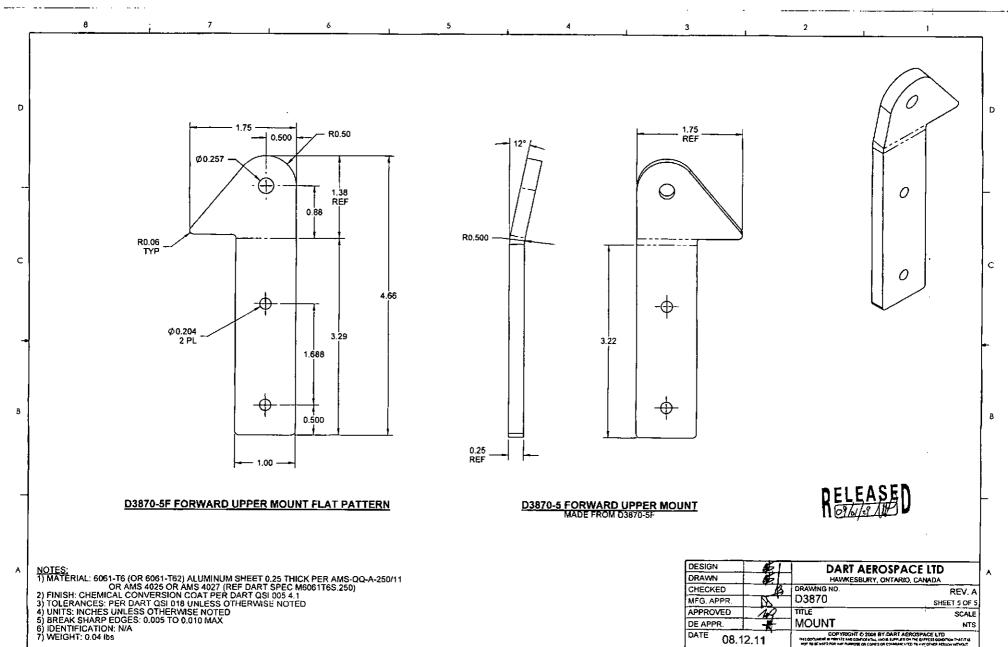


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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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	Torque W	/aves in E	xtrusio	n L	Drawing	$\mathbf{H}$	f Calibration				! 				
ļ	Turning S	equence			Finish	Out of	f Sequence								
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IN THE COMPANY PLANTONS ON COMPANY OF COMMINICATION OF COMPANY OF CHILD HELD

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NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE																
						_		_				•	QA Closed:	Date	<u>:                                    </u>	
Nork Orde	r:					1	DISPOSITION	,			AGAINST	ARTMENT	PROCESS			
	-					ı	Rework	Skid-tube Crosstube					Water Jet	Engineering		
Part N	o.						Scrap	1	Machining Small Fab				Proc	d. Eng. Coor.	Quality	
	_						Use-as-is	1	Therm	noforming	Finishing		Rec/Stor	e/Packaging	Other	
NCR N	lo.						Work Order Update			Large Fab	Composite		Supplier			
Root	Descr			crip	tion of work order update		Initial Action		ļ	Sign &						
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector	
oc/Data								1								
quip/Tooling													į			
perator												1				
1aterial	_															
etup								1								
ther													1		1 *	
rocess												İ				
upplier															ļ .	
raining				1												
napproved																
							<u>F</u>	AUL	T CATE	GORY						
Landi	ng G	ear					General				,				¬ '	
		Bending			1		Bend		Grain			-	Ovalized		Pressure/Forced	
		Centre No	Centre Not Concentric to O/S BOM/Route				BOM/Route		Hardware				Over/Under tolerance		Temperature/Cure	
		Cracks					Broken/Damaged		Inspecti	Inspection Incomplete		Ш	Part Incorrec	t	weld	
		Crushed/0	Crimped				Burrs		Instructions Incomplete/Unclear		/Unclear	Ш	Part Lost/Missing		Wrong Stock Pulled	
		Cuffs					Contamination		Maintenance			Ш	Part Moved			
		Heat Trea	Heat Treat Countersink					Mislabe	ele <b>d</b>			Positioned W	/rong	_		
		Inspection	n Strip in	Tube	İ		Cut Too Short		Misread	t			Power Loss/Surge Other			
		Ripples in	Bend				Drill Holes		Offset							
		Torque W	aves in E	Extrusio	n		Drawing		Out of (	Calibration		_				
		Turning Se	equence				Finish		Out of 9	Sequence						
		Wave/Tw	ist in <u>T</u> ub	ре			Folio	Outside Dimensions								

DQA:

Date:

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